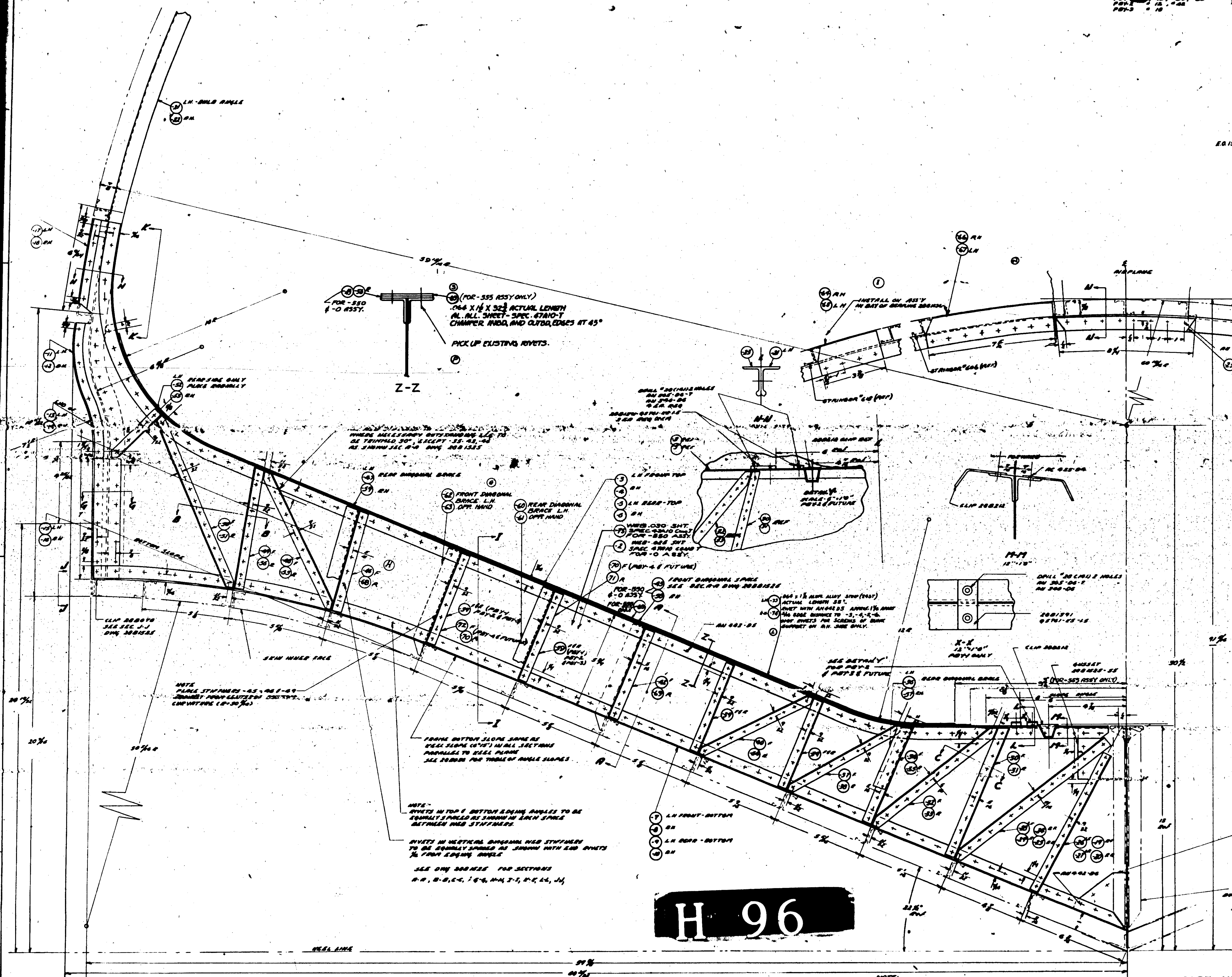


BUREAU CHANGES INCORPORATED
PBY-[redacted] 45, #59, #80
PBY-2 # 12, #42
PBY-3 # 10

LET.	ALTERATION	DATE	
F	TRACED TO DATE		
G	ADDED DIAGONAL BRACES -60, -61, -62, & -63 (1 EA REQ'D)		
H	CHANGE -44 TO 2 REQ'D AND -48 EXT. ANGLE (2 REQ'D)		
I	ADD -64 -65 -66 & -67 SKIN STIFFENERS (1 EA REQ'D)		
J	[illegible]		
K	CHANGED [illegible]		
L	ADDED -73 & -74 ON TOP OF FRAME		
M	ADDED -76 & -77 REPLACING -66 & -67 FOR PBY-5	11-17-39	
N	REMOVED -76 & -77 [illegible] REPLACED BY -66 & -67 [illegible] ON -550 ASSY FOR PBY-5		
O	ADDED -555 ASSEMBLY, ADDED NOTE.		
P	ADDED SECTION Z-Z FOR 28-5ME. (-555 ASSY)	11-26-40	
Q	REMOVED -64, -65, -66, -67 FROM B/M OF 550 & 555 ASSEMBLY		
R	IN B/M 2081212 (4) WAS (2) REQ'D FOR PBY-5.		

NOTE ~
B/M - 64, -65, -66, -67 USED ON -0 ASSEMBLY ONLY.

Note:— FOR -555 ONLY
DIAGONALS -62, -63 ARE TO BE INSTALLED ON AFT SIDE OF FRAME. -62 WILL BE INSTALLED ON STARBOARD SIDE AND -63 WILL BE INSTALLED ON PORT SIDE.
DIAGONAL BRACES WILL BE ATTACHED TO SAME STIFFENERS AND STRINGERS EXCEPT ON OPPOSITE SIDE OF B.F.

NOTE:
-35 -42 -71 -72 -68 TOP ENDS ARE CUT 90° FOR ATTACHMENT OF DIAGONALS

NOTE:
ALL RIVETS AN 442-05 UNLESS OTHERWISE SPECIFIED
DRILL [illegible] FOR AN 442-05 RIVETS
DRILL [illegible] FOR AN 442-06 RIVETS

NOTE:
LIST CONSISTS OF ANGLES (PLAIN EXT. & BULB) WITH CORRESPONDING DASH Nos. ALL EXTRUSIONS SPEC. 46A9 COND. T EXCEPT -370-10 WHICH ARE [illegible] COND. A HT. SR-53 (COND. T)

EXT. ANGLE DIE No. K-5401 -3 -4 -5 -6 -7 -8 -9 -10 -36 -43 -47 -50 -61 -62 -63, -57, -58, -59

EXT. ANGLE DIE NO K 6240 -11 -12 -13 -14 -17 -18 -26 -27 [illegible] -37 -38 -39 -40 -48 -49 -50 -51 -52 -53, -54, -55, -56

EXT. BULB ANGLE DIE No. K-3876 [illegible]

EXT. BULB ANGLE [illegible] -21 -22 -23

PLAIN ANGLE SPEC. 47A10 COND. A HT. SR 53 [illegible] -15 -16

DRAWN ANGLE SPEC. M-325 -64 -65 -66 -67, -76, -77

ALL AL. ALLOY SHEET SPEC. 47A10 COND. T EXCEPT AS NOTED
ALL AL. ALLOY EXTRUSIONS SPEC. 46A9 COND. T EXCEPT AS NOTED
HEAT TREAT ALL COND. A MAT. SPEC SR-53 TO COND. T.
RIVETS AL. ALLOY EXCEPT AS NOTED

PORT SIDE
LOOKING FWD

GP-GREEN PRIME FINISH

FINISH:- GP
Z-P- [illegible] ON PBY-1
Z-P- [illegible] ON PBY-2 & FUTURE GP

-33	PBY-5A	2081550	1
-555	28-5ME	2081000	
-550	PBY-5	2081000	
-0	PBY-4	2081000	
-0	PBY-3	[illegible]	
-0	PBY-2	[illegible]	
-0	PBY-1	[illegible]	
D.N.	MODEL	NEXT ASSY.	REQ.

REQUIREMENTS PER AIRPLANE

CONSOLIDATED AIRCRAFT CORP. BUFFALO, N. Y.

MATERIAL: NOTED | SPEC.: NOTED | HEAT TREAT: NOTED | FINISH: NOTED

NAME: BELT FRAME HULL - STA. 5.50

J 2081550